

Date: Monday, 12/05/2008 1:21:05 PM
 User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-742-013
Job Number	: 37973		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D412742013
This Issue	: 12/05/2008 S.O. No. :	Drawing Number	: RTN08-013
Prsht Rev.	: NC	Project Number	:
First Issue	: 13/03/2008 Type : SKIDTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 20/03/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JUD 08.5.12</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2.0

D412742013

Float Skidtube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Float Skidtube Instln

Qty 1 D412-742-013 original B30363 @ CHG003

Qty 1 D412-742-013 original B31709 @ CHG003

mf

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Disassemble all hardware.

2- Keep, and identify the following:

-1x D2571 saddle B 30094-1x D2572 saddle B 30593-1x D2573 saddle B 30594-1x D2574 saddle B 30595-2x D2876 spacer B 28016-2x D2877 spacer B 30055-16x D3403-1 bushings B 31712-8x D3403-3 bushings B 30393-1x D3405-041 GH lug B 26314-1x D3405-043 GH lug B 26315-1x D3407-041 tow ring B 30394

Discard all hardware.

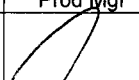
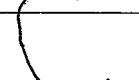
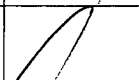
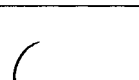
**** see original w/o, D412-742-013 B30363 for B#'s ****

D2571 / B30592 ✓
 D2571 saddle A B31714 ✓
 D2572 saddle A B31714 ✓
 D2573 A / B32167 ✓
 D2574 saddle A B31718 / B31722 ✓
 D2573 A / B31718 ✓

X PTO →

JUD 08-08-15 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-06-10	3.1	Reallocate saddles / 4x Lugs + Repowder COAT WHITE	W M-D	08-06-10 08/06/16	8 12	 QSW	 08/06/16	
8-06-10	3.2	Q.C.3 inspect powder COAT & chemical convention	FL	08/06/16	12	 08/06/18	 08/06/18	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 1:21:05 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Disassemble and identify the following:

- 1x D3564-5 B 32054
- 1x D3391-023 B 31848
- 1x D3391-025 B 31440
- 1x D3391-021 B 30925
- 1x D3564-1 B 31417
- 1x D3564-3 B 31419

1 => D3407-041 B 30394
1 => D3461-041 B 31346

discard all hardware, and give the D3566 gaskets to Jason.M.

**** see original w/o D412-742-043 B32123 for B#'s ****

All
DISCARDED
HJ

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

- Remove all Silver paint from all the parts.
- Try Hot pressure wash to remove silver paint on the tube it self.

HJ 08-05-13 (X2)

6.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

NA HJ

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powdercoat white per QSI005

HJ 08-05-13 (X2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/05/13 (2X)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pick the following to assemble:

HJ 08-5-13 (X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 1:21:05 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

NAS1330S3KB166

INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

B _____ Qty: _____

See attached.

PTD

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

NIA IF

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

NIA IF

13.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

GASKET

Batch: *B 38681*

JS

14.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: *B 38647*

JS

15.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

BOLT

Batch: *M 107737*

JS

16.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch: *M 105300*

JS

08-05-13 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	10.1	Install inserts AS per dwg.	<i>[Signature]</i>	08-05-13	(2)	<i>[Signature]</i> 08-05-13	<i>[Signature]</i> 08-05-13
	10.2	QCS Insert inspection	<i>[Signature]</i>	08-05-14	(1)	<i>[Signature]</i> 08-05-13	<i>[Signature]</i> 08-05-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 12/05/2008 1:21:05 PM
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Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

BOLT

Batch: M107376

91A

18.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 88.0000 Each(s)

washer

Batch: M107939

91D 08-5-13

(V2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/05/18 (x2)

20.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2747

Bolt

310331

JS 08/06/18 (x2)

(P10) →

21.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

M106519

JS 08/06/18 (x2)

22.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M107287

JS 08/06/18 (x2)

23.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

M103914x3

M105423x2x13

JS 08/06/18 (x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/18	# 20.1	ADD Qty x16 D3403-1 Bushings B# <u>36303</u> x 32	JS	08/06/18	32	JS	08/06/18
08/06/18	# 20.2	ADD Qty x8 D3403-3 Bushings B# <u>B37146</u> x16	JS	08/06/18	16	JS	08/06/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 1:21:05 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN6C12A

BOLT



(P002)

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

M104289

AS 08/06/17 (x2)

25.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 AN960C416L

Washer

M107050

AS 08/06/18 (x2)

26.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C616L

Washer

M18918

All Same Batch
End of Batch. = 16
- take out from stock please

AS 08/06/18 (x2)

27.0

AN960C716L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M105792

AS 08/06/18 (x2)

28.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 58.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M17285

AS 08/06/18 (x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/18	24.1	ADD Qty x2 D 2876 SADDLE SPACERS B# <u>B36275</u> x 4	JS	8/6/18	4	JS/MP	JS/08/06/18
08/06/18	24.2	ADD Qty x2 D 2877 SADDLE SPACERS B# <u>B34818</u> x 4	JS	8/06/18	4	JS/MP	JS/08/06/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 1:21:05 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

NAS1515H4L

WASHER



(PHD) →

Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 NAS1515H4L

Washer

M107008

JS 08/06/18 (x2)

30.0

NAS1515H6L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H6L

Washer

M18918

JS 8/06/18 (x2)

31.0

NAS1515H7L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H7L

Washer

M100727

JS 08/06/18 (x2)

32.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

33519

JS 08/06/18 (x2)

33.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

33276

JS 08/06/18 (x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/18	# 29.1	ADD Qty of 1 D 3407-041 Tow Ring BA <u>B35780</u>	<i>[Signature]</i>	8/06/18	x2	<i>[Signature]</i> 10/10/18	<i>[Signature]</i> 08/06/18
08/06/18	# 29.2	u/a Sostokis					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 1:21:05 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

Batch:

M1063a2

AS 08/06/18 (X2)

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08-06-18 (1)
kit is packaged in box

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels and paperwork required with the new batch # @ CHG005

Identify and pack for shipping as per PPP D412-742-013

Location:

PPP Rev:

Rev E

AS 08/06/18 (X2)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01

Job Completion



MF 08-06-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/03/2008 9:05:53 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-742-013
Job Number	: 37973		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D412742013
This Issue	: 18/03/2008 S.O. No. :	Drawing Number	: RTN08-013
Prsht Rev.	: NC	Project Number	:
First Issue	: 13/03/2008 Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 20/03/2008 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2.0	D412742013	Float Skidtube Instln
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Float Skidtube Instln

Qty 1 D412-742-013 original B30363 @ CHG003

Qty 1 D412-742-013 original B31709 @ CHG003

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1- Disassemble all hardware.

2- Keep, and identify the following:

- ✓ -1x D2571 saddle B 30094
- ✓ -1x D2572 saddle B 30593
- ✓ -1x D2573 saddle B 30544
- ✓ -1x D2574 saddle B 30595
- ✓ -2x D2876 spacer B 28016
- ✓ -2x D2877 spacer B 30055
- ✓ -16x D3403-1 bushings B 31712
- ✓ -8x D3403-3 bushings B 30393
- ✓ -1x D3405-041 GH lug B 26314
- ✓ -1x D3405-043 GH lug B 26315
- ✓ -1x D3407-041 tow ring B 30394

Discard all hardware.

**** see original w/o, D412-742-013 B30363 for B#'s ****

Packed as is

- ⊗ D2571 B31647 x1, B30592 x1
- ⊗ D2572 B30593 x1, B31714 x1
- ⊗ D2573 B32167 x1, B31717 x1
- ⊗ D2574 B31718 x1, B31722 x1
- ⊗ D3405-041 B26314 x2
- ⊗ D3405-043 B26315 x2
- Picked from storage
- ⊗ D3407-041 B35780 x2
- ⊗ D2876 B36275 x4
- ⊗ D2877 B31818 x4
- ⊗ D3403-1 B36303 x32
- ⊗ D3403-3 B37146 x16

08/06/18 (42)

Date: Tuesday, 18/03/2008 9:05:53 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Disassemble and identify the following:

mid
AFT
Fwd
-1x D3564-5 B _____
-1x D3391-023 B _____
-1x D3391-025 B _____
-1x D3391-021 B _____
-1x D3564-1 B _____
-1x D3564-3 B _____

MID B31843
B31315
AFT B31318
B31592

Fwd B30924
B30925

discard all hardware, and give the D3566 gaskets to Jason.M.

**** see original w/o D412-742-043 B32123 for B#s ****

B37973

D412742013

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M107550



01/05/2008
S.174 13.45

Comment: HAND FINISHING RESOURCE #1

- Remove all Silver paint from all the parts. - 11 08-07-17(x2)
- Try Hot pressure wash to remove silver paint on the tube it self.

EL 8-4-1

#1 326.0 F
#2 --- F
#3 Bover F
#4 --- F

6.0

QC

QUALITY CONTROL



Comment: QUALITY CONTROL

See Jason to complete w/o after the paint is removed.

Job Completion



Rev E

Float-Skid-Tubes
2x Mid { B31843 }
 { B31315 }

2x Fwd { B30924 }
 { B30925 }

2x AFT { B31318 }
 { B31592 }

B31315 + B30925 + B31318

B31843 / B30924 / B01592

Date: Monday, 12/05/2008 1:21:05 PM
 User: Julie Lecocq

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	D412-742-013
Job Number :	37973	Part Number :	D412742013
Estimate Number :	10804	Drawing Number :	RTN08-013
P.O. Number :		Project Number :	
This Issue :	12/05/2008	Drawing Revision :	
Prsht Rev. :	NC	Material :	
First Issue :	13/03/2008	Due Date :	20/03/2008
Previous Run :	00015	Qty:	2 Um: Each
Written By :			
Checked & Approved By :			
Comment :			

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2.0

D412742013

Float Skidtube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Float Skidtube Instln

Qty 1 D412-742-013 original B30363 @ CHG003

Qty 1 D412-742-013 original B31709 @ CHG003

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Disassemble all hardware.

2- Keep, and identify the following:

-1x D2571 saddle B _____

-1x D2572 saddle B _____

-1x D2573 saddle B _____

-1x D2574 saddle B _____

-2x D2876 spacer B _____

-2x D2877 spacer B _____

-16x D3403-1 bushings B _____

-8x D3403-3 bushings B _____

-1x D3405-041 GH lug B _____

-1x D3405-043 GH lug B _____

-1x D3407-041 tow ring B _____

Discard all hardware.

**** see original w/o, D412-742-013 B30363 for B#'s ****

Date: Monday, 12/05/2008 1:21:05 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 37973

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: _____

REFERENCE ONLY

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels and paperwork required with the new batch # @ CHG003

JUD 08.5.13

Identify and pack for shipping as per PPP D412-742-013

Location: _____

PPP Rev: _____

37.0

QC21

FINAL INSPECTION/W/O RELEASE



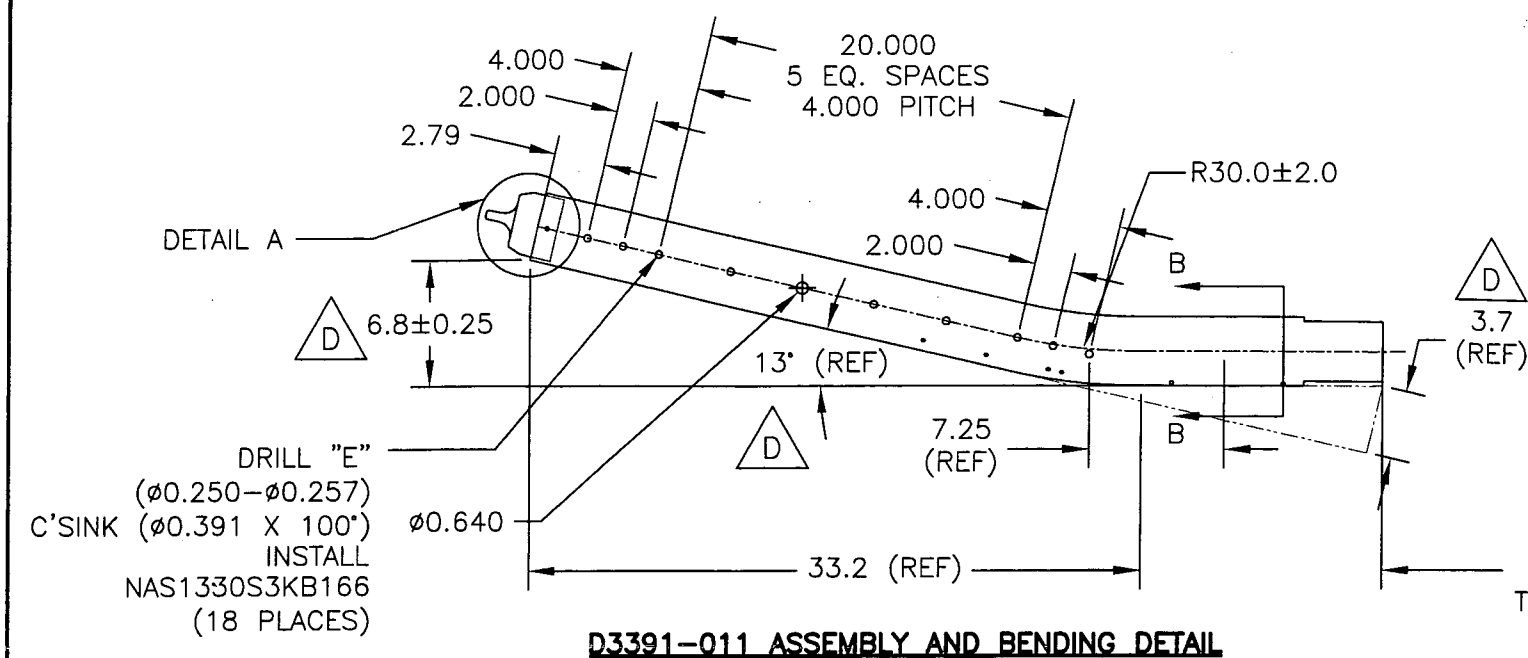
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Job Completion

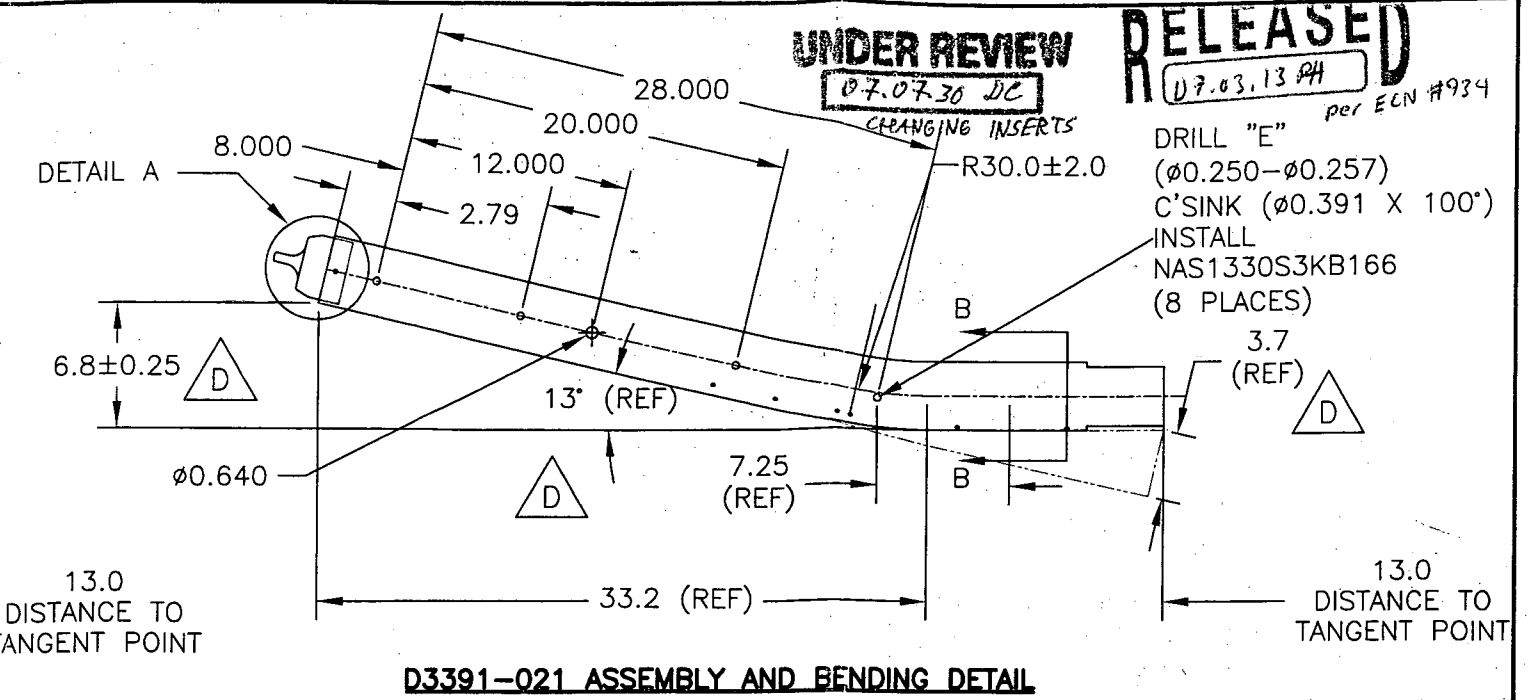


UNDER REVIEW
07.07.30 DC

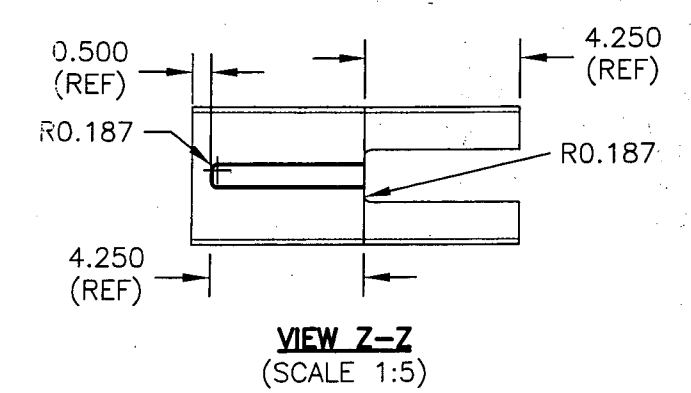
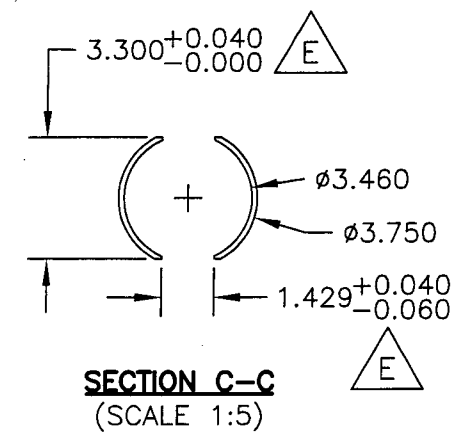
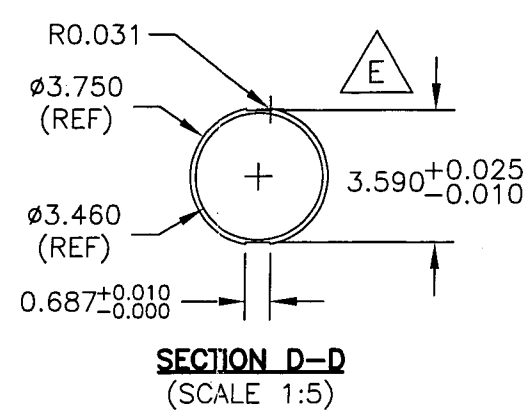
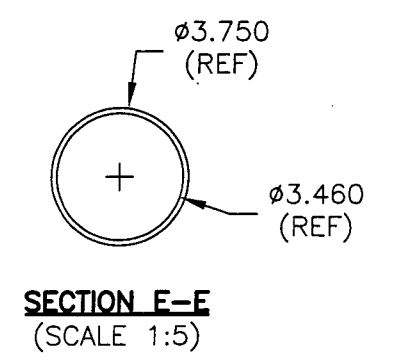
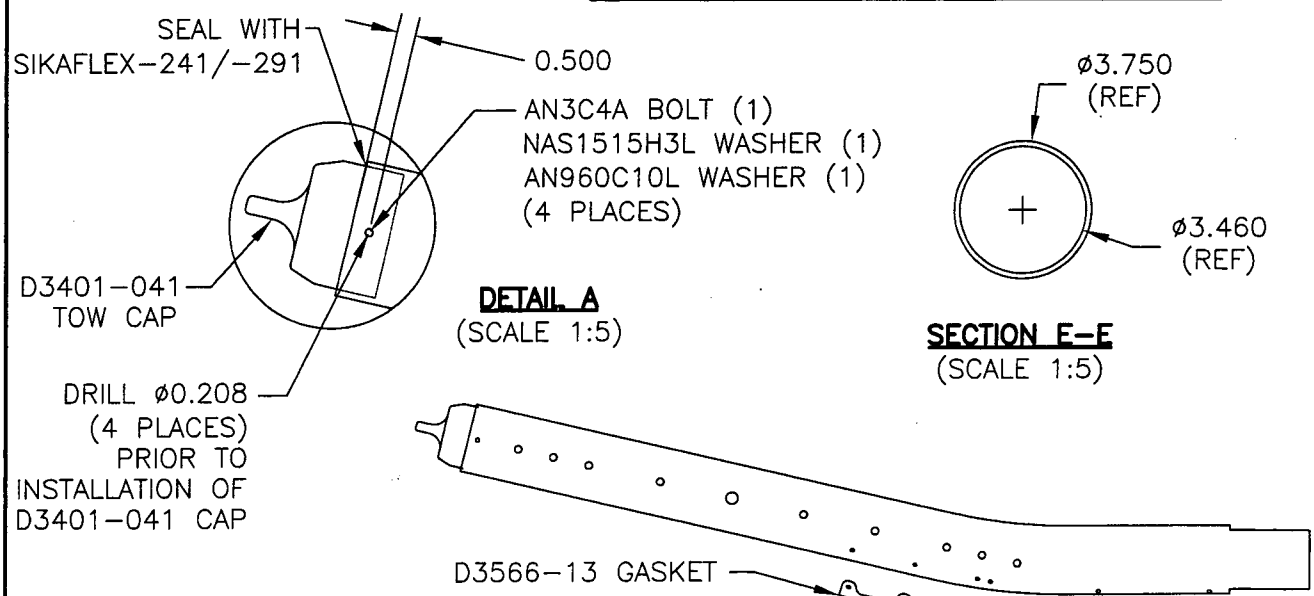
RELEASED
07.03.13 PH
per ECN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



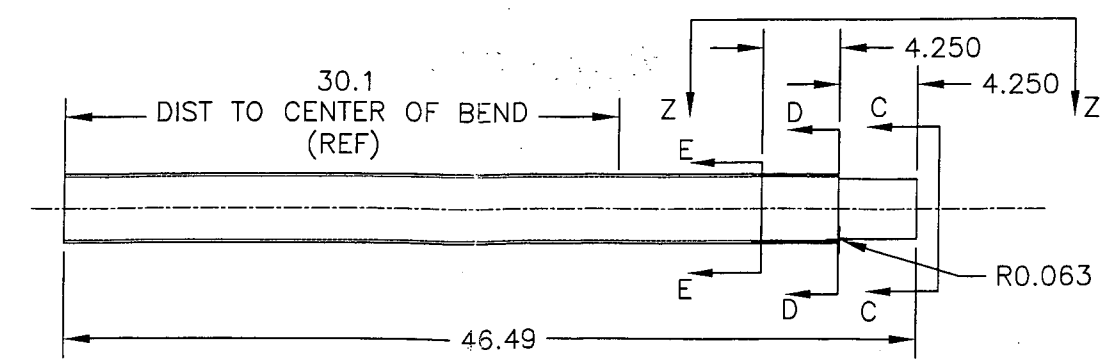
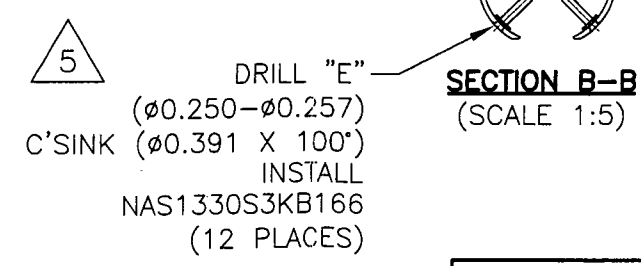
D3391-021 ASSEMBLY AND BENDING DETAIL



D3391-011/-021 WEARSHOE ASSEMBLY

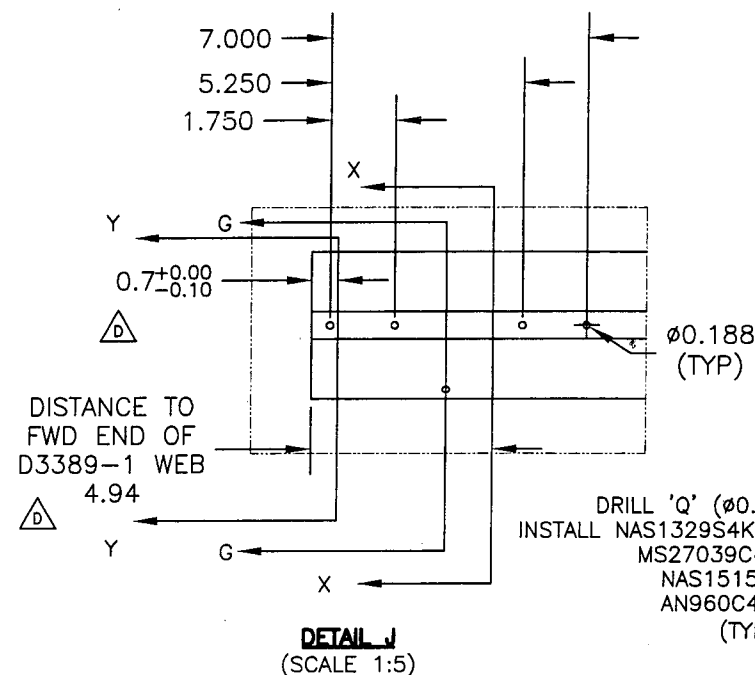
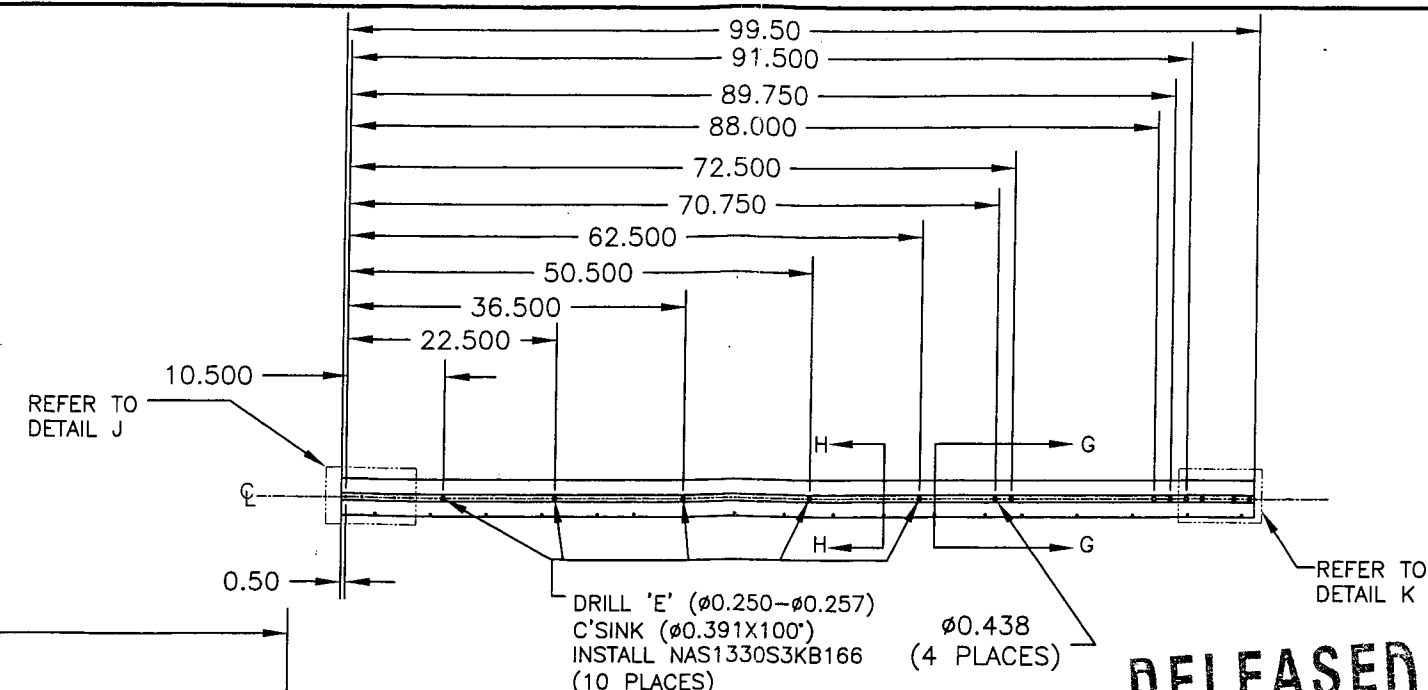
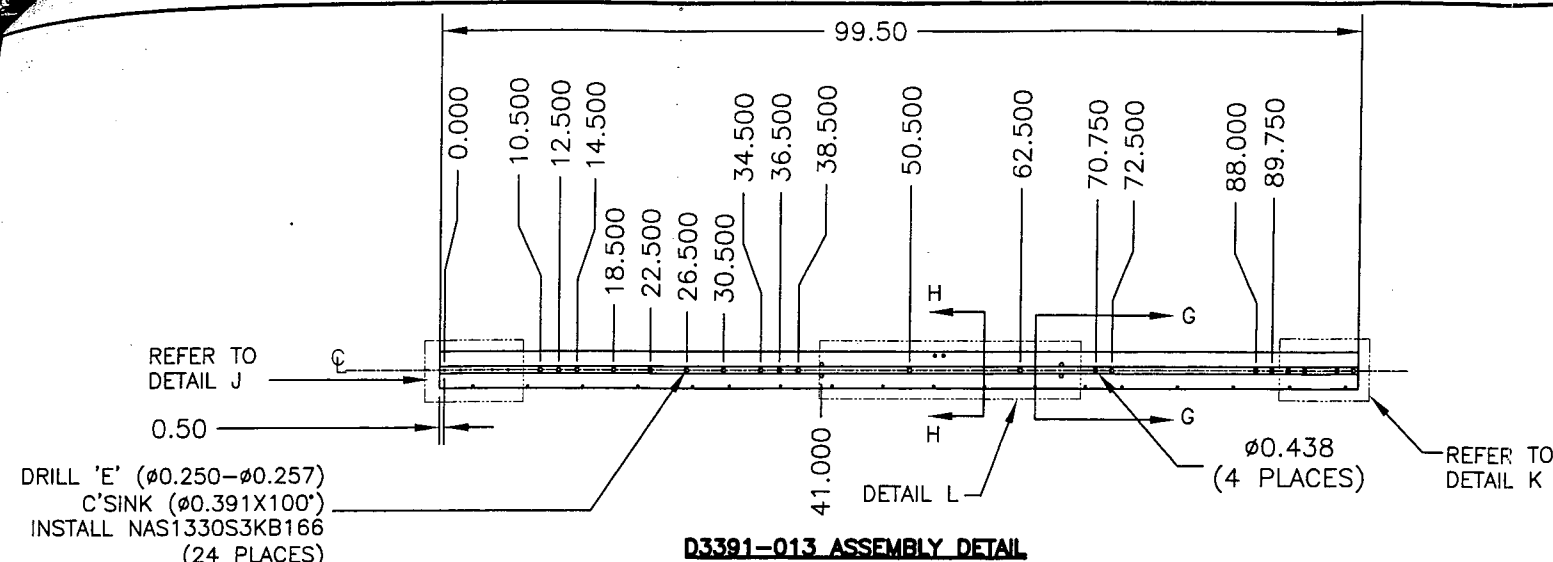
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

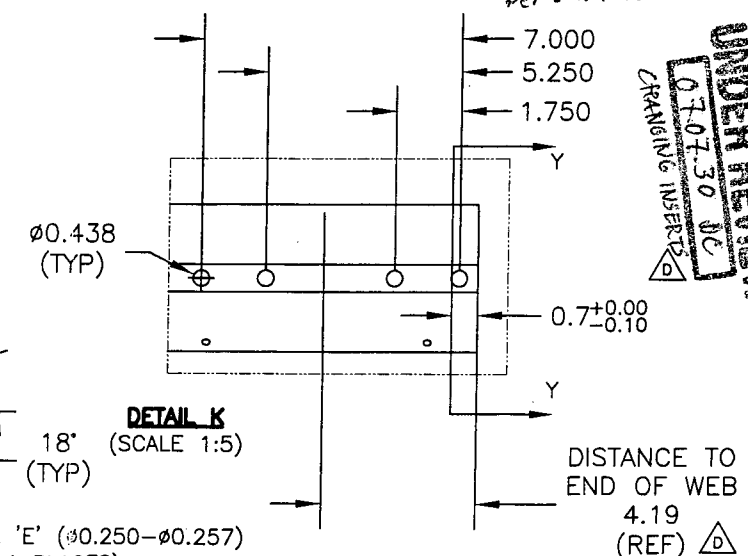
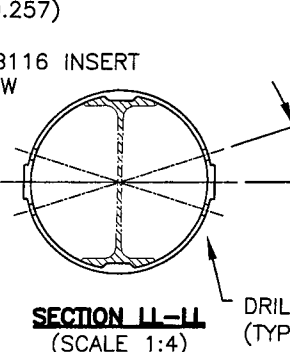
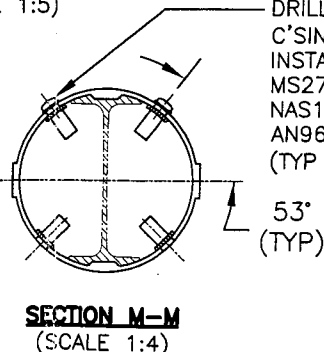
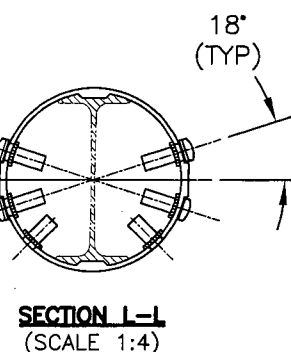
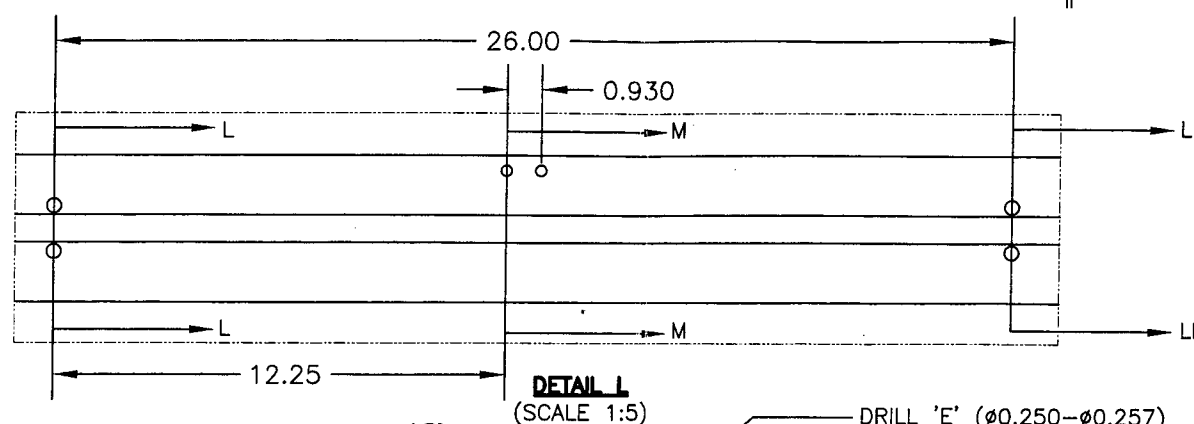


D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10



DRILL 'Q' (ø0.332-ø0.338)
INSTALL NAS1329S4KB140 INSERT
MS27039C1-09 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)



RELEASED
07.03.13 RH
Per ELN #934

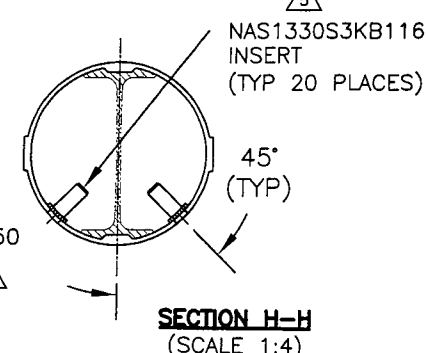
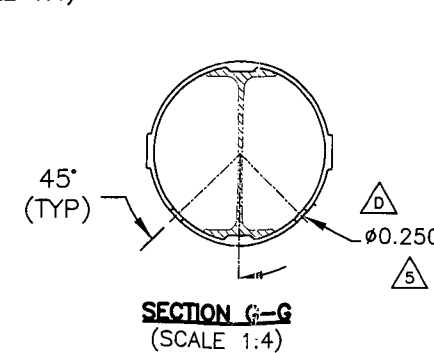
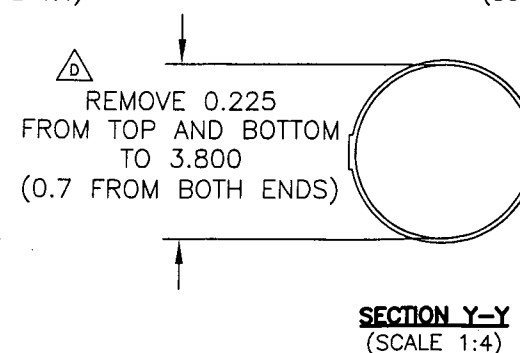
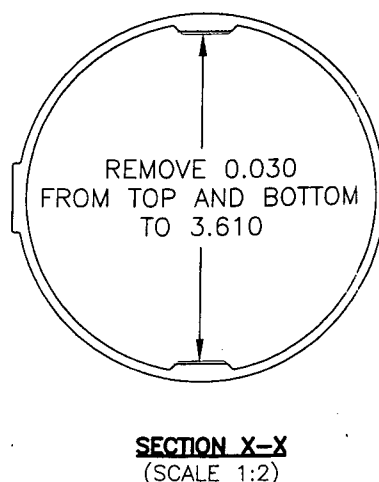
UNDER REVIEW
07.07.30 JC
CRANKING INSERT

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015



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DESIGN

DRAWN BY

CHECKED

APPROVED

DATE

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.

REV. F

D3391

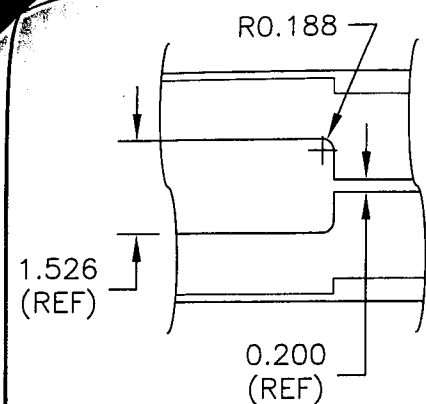
SHEET 3 OF 5

TITLE

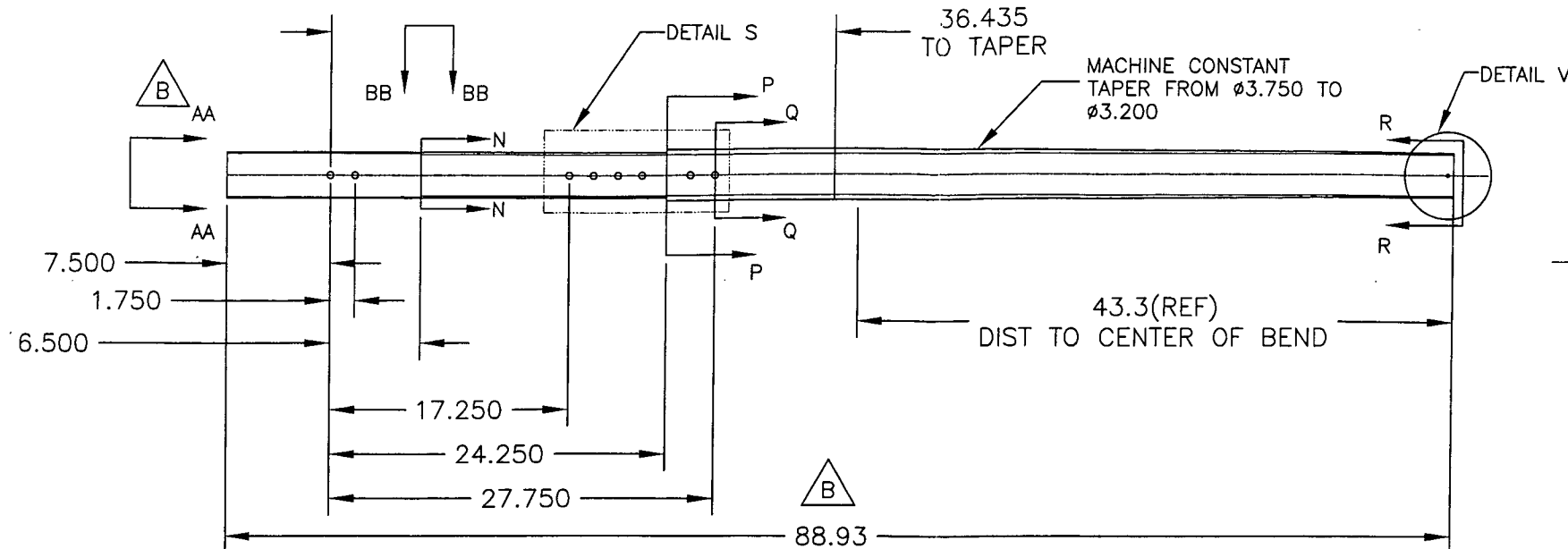
SCALE

412 FLOAT SKIDTUBE

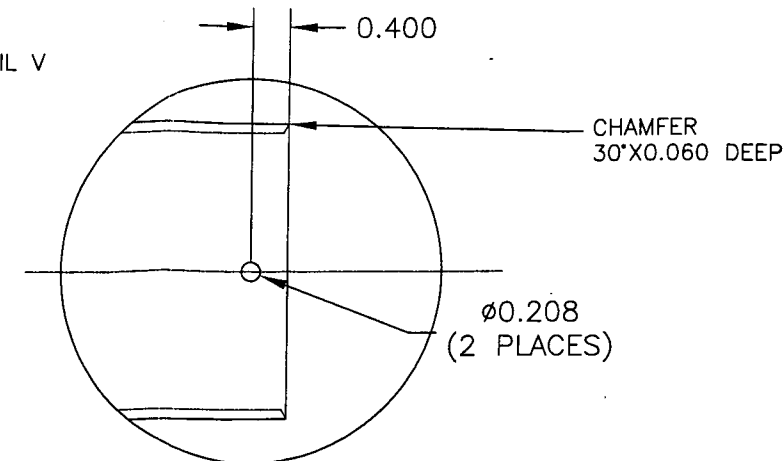
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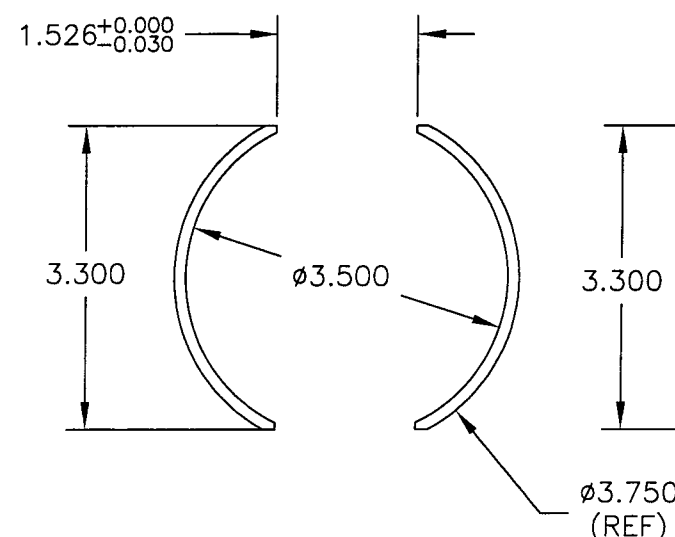
VIEW BB-BB
(SCALE 1:3)



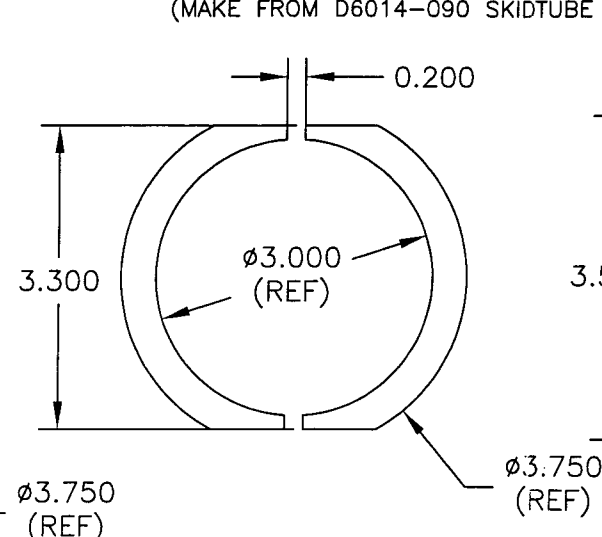
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



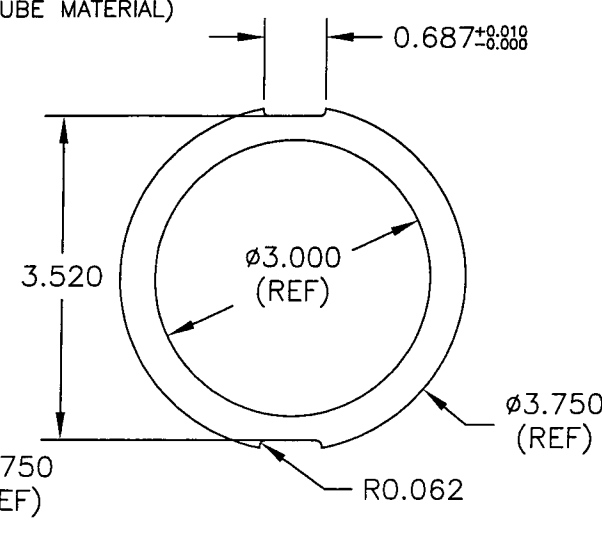
DETAIL V
(SCALE 1:2)



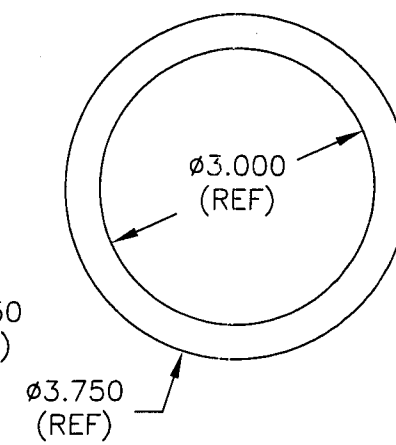
SECTION AA-AA
(SCALE 1:2)



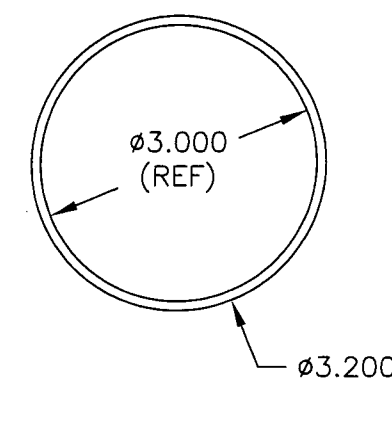
SECTION N-N
(SCALE 1:2)



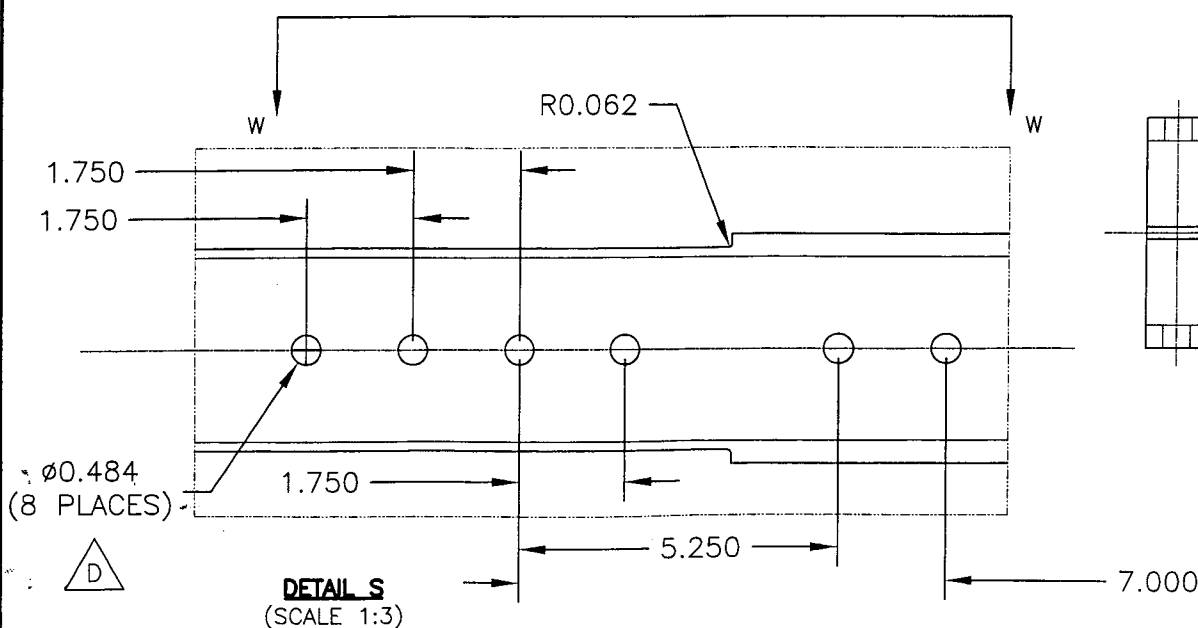
SECTION P-P
(SCALE 1:2)



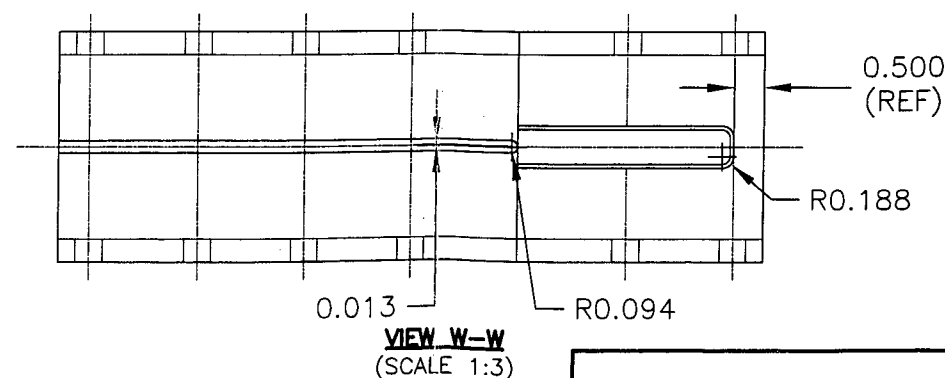
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)

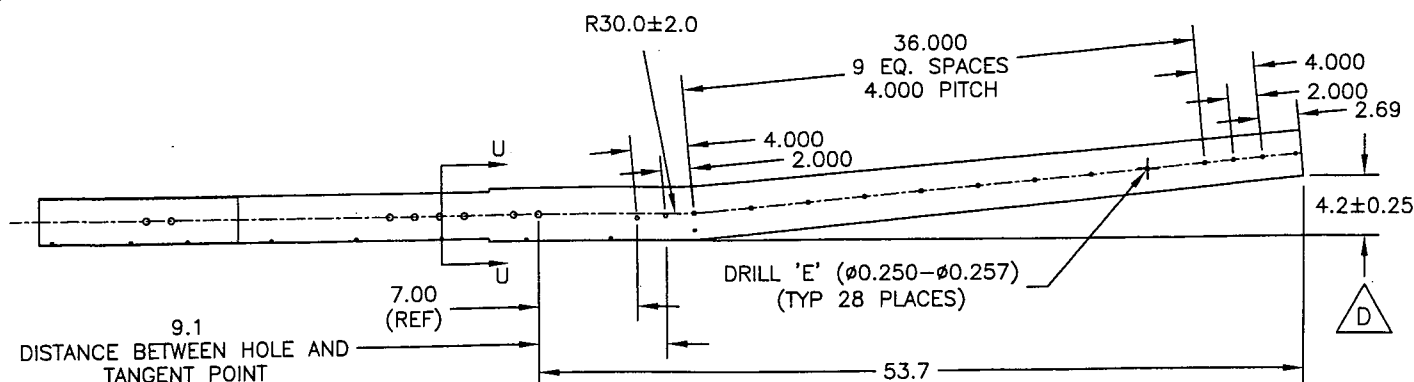


VIEW W-W
(SCALE 1:3)

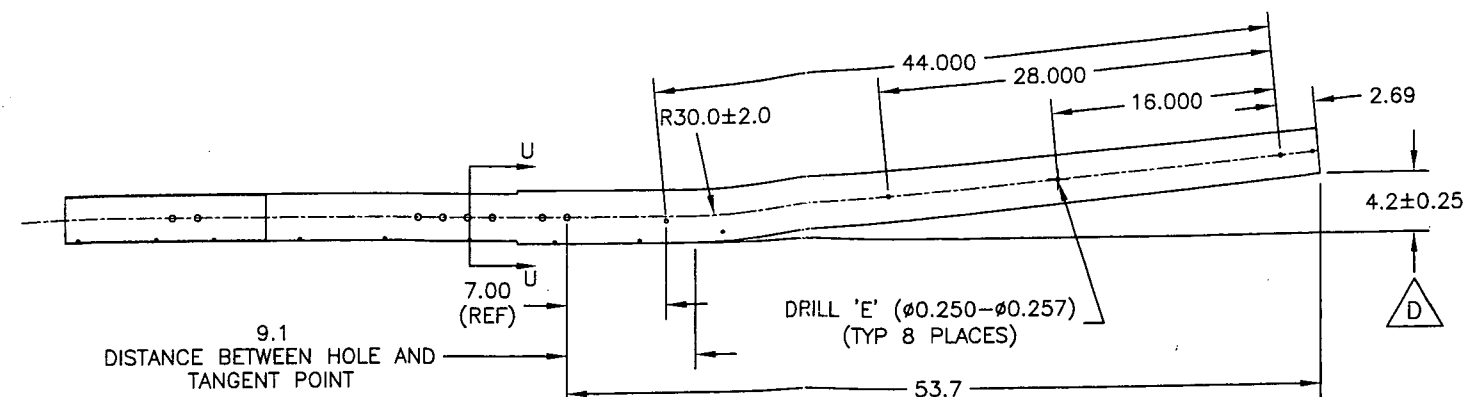
UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

RELEASED
07.03.13 PH
per ECN #934

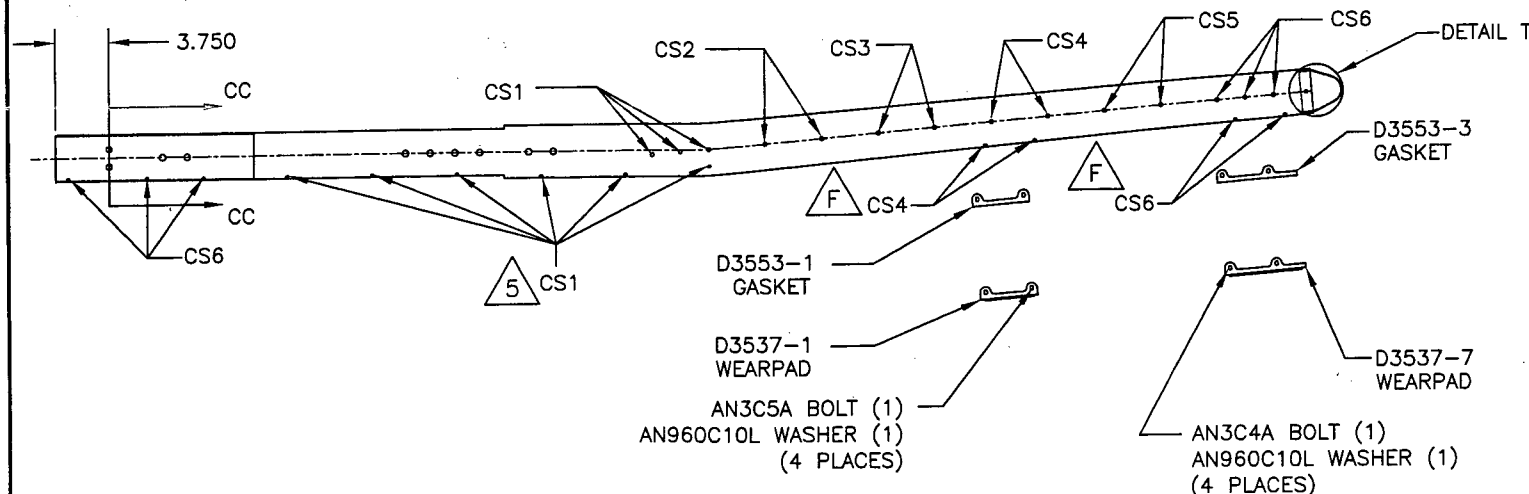
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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:12	



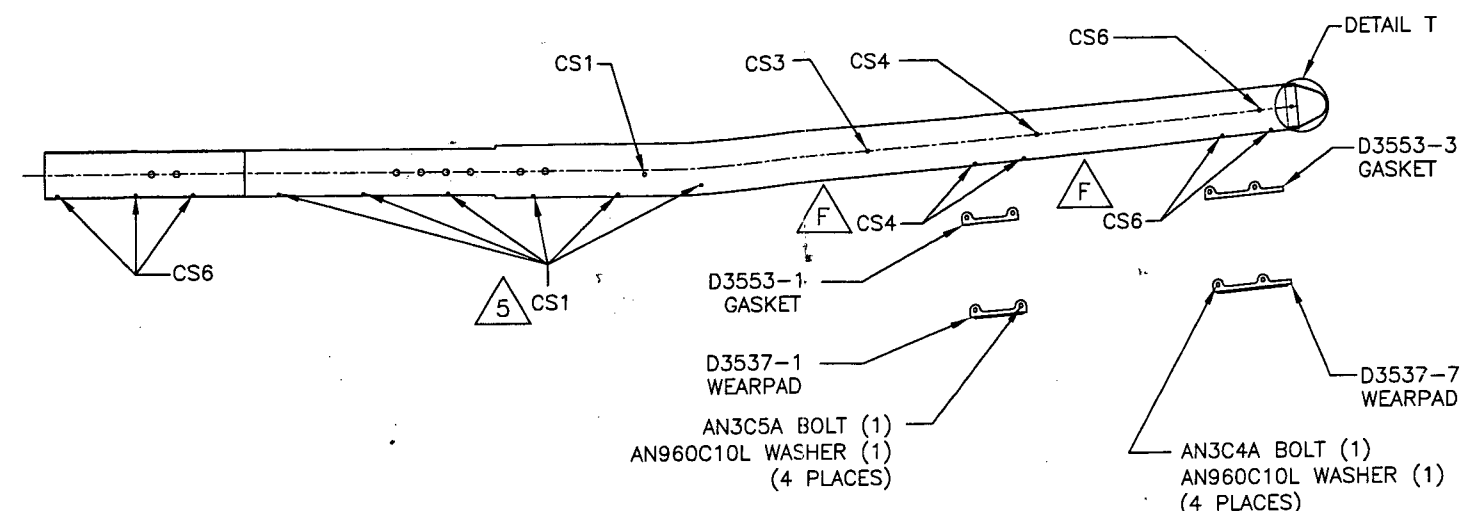
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



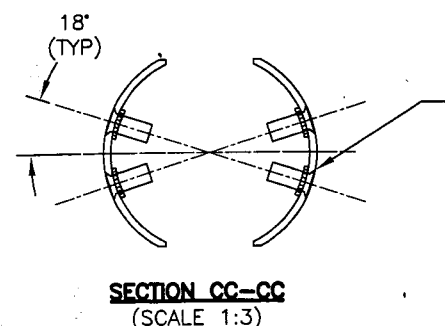
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

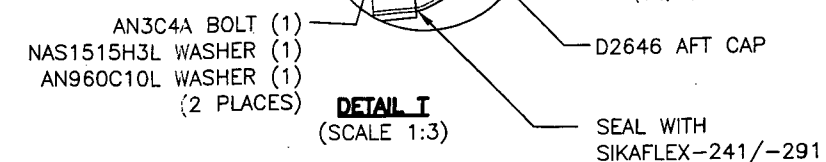
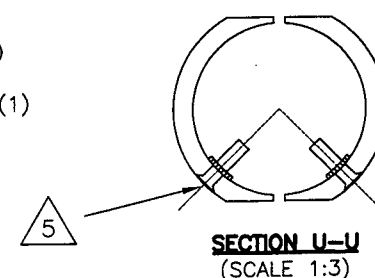
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

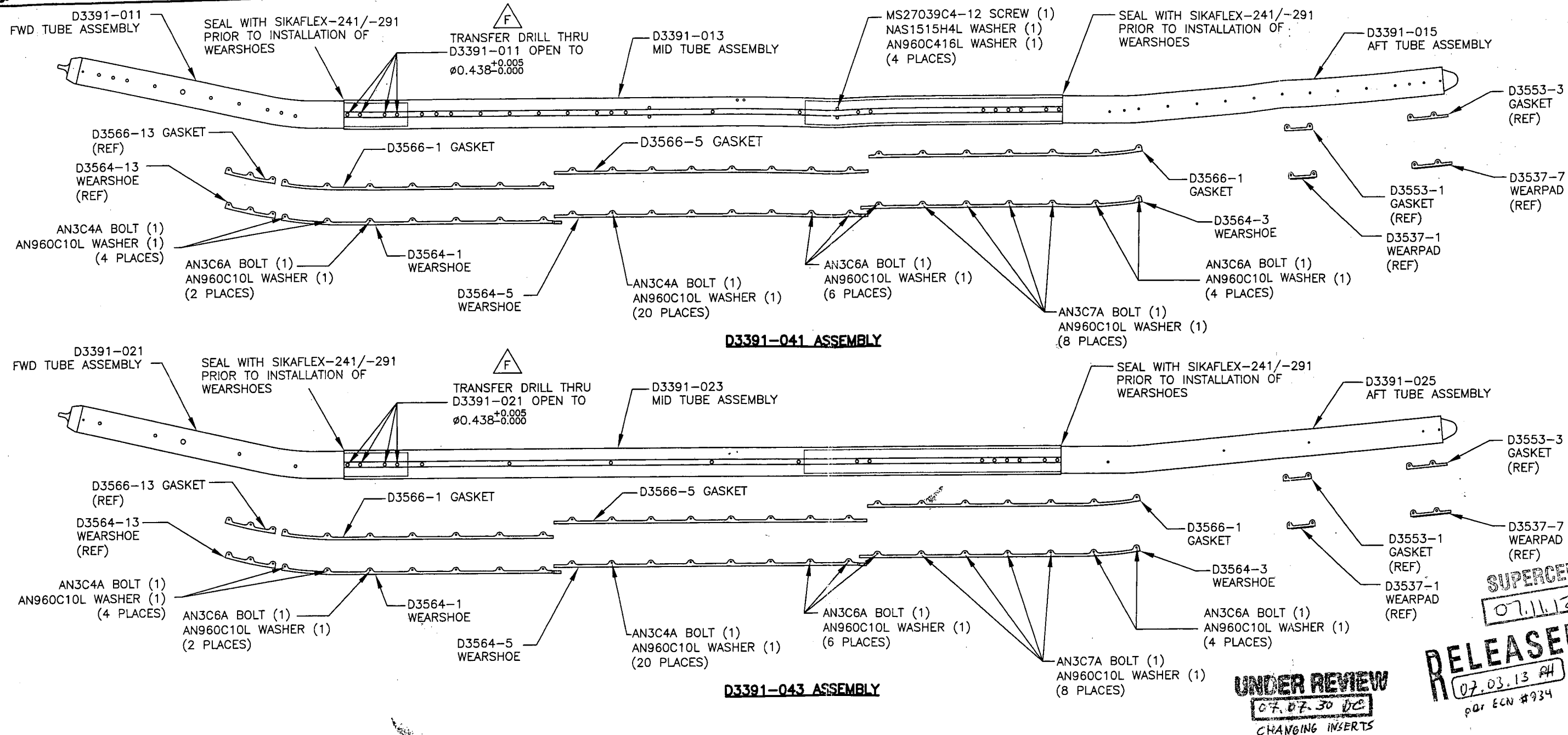


RELEASED
07.03.13 RH
per ECN #934
UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

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DESIGN RH	DRAWN BY RH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12



SUPERCEDED BY
07.11.12
RELEASED
07.03.13 PH
per ECU #934

UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391/Ø0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE,EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.01.18	TITLE 412 FLOAT SKIDTUBE
		DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
		DRAWING NO. D3391
		REV. F
		SHEET 1 OF 5
		SCALE NTS

116

40

104575 ✓

166

84

103954 ✓

266

12

104651 ✓

316

4

104818 ✓

366

28

104818 ✓

D3564-13

2

38253

-1

2

33243 / 39286 ✓

-5

2

38409

*MISSING ONE

-3

2

*33764 / 34052

D3537-1

2

37749 ✓

-7

2

33869 ✓

D3566-13

2

32244 ✓

D3566-1

4

38681 *

-5

2

38647 ✓

D3553-1

2

33868 ✓

D3553-3

2

33870 ✓

AN3C4A 48 107737 ✕

AN3C6A 24 105300

AN3C7A 16 107376

AN960C10L 88 102939

AN3C5A 8 107737

ASISISH3L 12 107394 ✓

D2646 2 36184

D3401-041 2 36216

Float-Tube Assembly (inserts Only)!

1. Mid-Tube Assembly Parts list: B31315

Part Name:	Qty:	Batch no:
NAS133053KB116 inserts	20	M104575
NAS133053KB166 inserts	10	M103954

2. FWD Tube Assembly Parts list: B30925

Part Name:	-Qty:	Batch no:
NAS133053KB166 inserts	20	M103954

3. AFT. Tube Assembly Parts list: B31318.

Part Name:	Qty:	Batch no:
NAS133053KB366 inserts	14	M104818
NAS133053KB316 inserts	2	M104818
NAS133053KB266 inserts	6	M104651
NAS133053KB166 inserts	12	M103954

install inserts / 08-05-14 (X1) JH

QC#s inspect inserts & order 1/14 (X1)

use A drop of Sikaflex in each insert holes

LPS { Both sides } ~~M106044~~ M107804 08/10
2 of web

Float-Tube Assembly Parts Lists

1. Wear shoes / Wear pads:

END Caps:

D2444 (x1) B36184

Tow Caps:

D34610-41 (x1)

B36216

Part No:	Qty:	Batch no:
D3564-13	1	B338253
D3564-1	1	B33243
D3564-5	1	B38409
D3564-3	1	B33801 B33764
D3537-1	1	B37749
D3537-7	1	B33869

2. Gaskets:

Part No:	Qty:	Batch no:
D3566-13	1	B32744
D3566-1	2	B38681
D3566-5	1	B38647
D3553-1	1	B33868
D3553-3	1	B33870

3. Bolts / Washers:

Part No:	Qty:	Batch no:
AN3C4A	24	M107737
AN3C-6A	12	M105300
AN3C-7A	8	M107376
AN960-C-10L	44	M107939
AN3C-5A	4	M107737

* PUT A DROP OF SIKAFLEX in each hole

PS PROCON M104251
 2 ALL BOLTS AND SHIT
 FASTENERS

MAS1515H-3L M107804 08/10

(X6) M187394

21 08.05-14

(X1)

Float-Tube Assembly (Inserts Only)

1. Mid-Tube Assembly Parts list: B31843

Part Name:	QTY:	BATCH NO:	*USE A DROP
NAS 133053K13 166 (inserts)	20	M104575,	OF SIKAFLEX in each hole before installing inserts!
NAS 133053K13 166 (inserts)	10	M103954 ✓	M107804 08/10

2. FWD Tube Assembly Parts list: B30924

Part Name:	QTY:	BATCH NO:	*USE A DROP OF SIKAFLEX in each hole before installing inserts!
NAS 133053K13 166 (inserts)	20	M103954	M107804 08/10

3. AFT-Tube Assembly Parts list: B31592

Part Name:	QTY:	BATCH NO:	*USE A DROP SIKAFLEX in each hole before installing inserts!
NAS 133053K13 366 (inserts)	14	M104818	GOODAMIT!
NAS 133053K13 316 (inserts)	2	M104818	M107804
NAS 133053K13 266 (inserts)	6	M104651	08/10
NAS 133053K13 166	12	M103954 ✓	

*KPS { Both sides of web }
All Tubes!

M106096
install inserts All 08-05-14

13

QC #5 inspect and sign off

Float-Tube Assembly PARTS lists

1. Wearshoes/Wearpads:

PART NO:	QTY:	BATCH NO:
D3564-13	1	B38253 x same
D3564-1	1 1339286	B33243 Thingy!
D3564-5	1	B38409
D3564-3	1	B33764 B34052
D3537-1	1	B37749
D3537-7	1	B33869
	#	

2. GASKETS:

PART NO:	QTY:	BATCH NO:
D3566-13	1	B32744 * HERE
D3566-1	2	B38681 TOO!
D3566-5	1	B38647
D3553-1	1	B33868
D3553-3	1	B33870
	#	

3. BOLTS / Washers:

PART NO:	QTY:	BATCH NO:
AN3C-4A	24	M107737 * PUT A DROP OF
AN3C-6A	12	M105300 Sika flex
AN3C-7A	8	M107376 M107804
AN3C-5A	4	M107737 08/10
AN960C-10L	44	M107939
NAS1515H-3L	6	M107394

All FASTENERS coated
with Procron LPS M104251

JP 08-05-14 (21)

END CAPS:

PART NO:

D2646

D34010-41

(TOW CAP)

QTY:

1

1

BATCH NO:

B36184

B36216

#

TEST-FIT saddles on skid-tube!

MASTER DOCUMENT LIST

STATUS	DRAWING #	REV	DESCRIPTION	DATE
R	IIN-D412-742	C	INSTALLATION INSTRUCTIONS	07.01.08
R	ICA-D412-742	2	INSTRUCTIONS FOR CONTINUED AIRWORTHINESS	07.01.08
R	QSI 004	06B	WELDING	06.11.14
R	QSI 005	09A	FINISHING	06.09.14
R	QSI 015	04B	BONDING	06.11.07
R	QSI 018	03B	STANDARD TOLERANCES	06.08.03
N/C	D2500	F1	EXTRUSION	01.04.17
N/C	D2571	E	SADDLE	05.07.13
N/C	D2572	E	SADDLE	05.07.13
N/C	D2573	E	SADDLE	05.07.13
N/C	D2574	E	SADDLE	05.07.13
N/C	D2577	E	WEARSHOE	00.09.22
R	D2646	C	AFT CAP	06.12.20
N/C	D2747	B	SET SCREW	05.03.09
N/C	D2876	B	SADDLE SPACER	06.06.02
N/C	D2877	B	SADDLE SPACER	06.06.02
N/C	D2913	B	DOUBLER	99.10.18
N/C	D3389	C	412 WEB	06.01.23
R	D3391	F	412 FLOAT SKIDTUBE	07.01.18
N/C	D3401	B	TOW CAP	05.06.09
N/C	D3403	B	BUSHING	06.01.23
N/C	D3404	B	GHW LUG	05.06.14
N/C	D3405	A	GHW LUG ASSEMBLY	05.03.08
N/C	D3407	C	TOW RING	05.09.09
N/C	D3417	C	WASHER	05.06.30
N/C	D3456	A	WASHER	05.09.01
N/C	D3460	A	WEARSHOE	05.10.04
N/C	D3499	B	CABLE GUARD	06.08.15
N	D3533	A	SET SCREW	06.07.12
N	D3537	B	WEARPAD	07.03.20
N	D3553	A	GASKET	07.01.11
N	D3564	B	WEARSHOE	07.03.20
N	D3566	A	GASKET	06.12.18
N	D3591	A	BUSHING	07.01.16
N/C	D6013	A	SKIDTUBE MATERIAL	05.03.18
N/C	D6014	A	SKIDTUBE MATERIAL	05.03.18
N/C	DSI 9319	A	WEARSHOE INSTALLATION	06.01.09
N/C	DSI 9330	D	CABLE GUARD INSTALLATION	06.08.24
N/C	DSI 9336	A	BOLT LENGTH CHANGE	06.05.19
N	DSI 9364	B	BUSHING INSTALLATION	07.03.20
N	DSI 9367	A	D412-742 WEARSHOE KITS	07.02.09

Revision	Issue Date	Prepared By	Approved By
A	05.04.01	PH	DS
B	05.06.21	PH	DS
C	05.10.05	PH	DS
D	06.01.27	PH	DS
E	06.04.26	MB	DS
F	06.06.02	MB	DS
G	06.08.24	MB	DS
H	07.03.20	PH	DS

Job #33442

*LEGEND

R = Revised
N/C = No Change
N = New

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Revision: H
Date: 07.03.20

Change Record

Part Number D412-742-013
Description FLOAT SKID TUBE

Page 1 of 1

[illegible]

Date: Friday, 06/04/2007 3:05:14 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 31709		
Estimate Number	: 10366		
P.O. Number	: <i>NIA</i>	Part Number	: D412742013
This Issue	: 06/04/2007	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: UNDER REVIEW <i>07.04.09</i>
First Issue	: <i>NIA</i>	Project Number	: N/A
Previous Run	: 30970	Drawing Revision	: N/A
	Type : LANDING GEAR	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 13/04/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013

CHG 003*07/04/19K3**CHG 001**9354**07.04.09*

2.0	31709A	FLOAT SKID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B *B31**32124**7/5/11**50*

3.0	D2571	Saddle, Fwd, Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2571 Saddle Fwd Outside

Batch

30094

4.0	D2572	Saddle, Fwd, In
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2572 Saddle Fwd Inside

Batch

1350593

Date: Friday, 06/04/2007 3:05:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 31709

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2573 Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2573

Saddle Aft Outside

Batch

B30594 ✓

6.0 D2574 Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2574

Saddle Aft Outside

Batch

B ~~30597~~ B30593 ✓

7.0 D2747 Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description

4 D2747

Bolt

Batch

B30818 ✓

8.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2876

Saddle Spacer

Batch

B28016 ✓

9.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2877

Saddle Spacer

Batch

B30055 ✓

From dispenser as to 1
28481

10.0 D34031 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description

16 D34031

Bushing

Batch

B31712 ✓

(16)

7/1/09 SO

Date: Friday, 06/04/2007 3:05:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 31709

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D34033 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3403-3

Bushing

1330393 ✓

12.0 D3405041 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

1326514 ✓

13.0 D3405043 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

1326515 ✓

14.0 AN4C6A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

1101418 ✓

15 1102039 ✓

15.0 AN4C46A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

1119529 ✓

16.0 AN4C52A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

1100334 ✓

1100340 ✓

7/4/03 S9

Date: Friday, 06/04/2007 3:05:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 31709

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 AN6C12A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

8 M101467 X

M104289 X

18.0 AN960C416L WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 AN960C416L

Washer

M100651 X

19.0 AN960C616L WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C616L

Washer

M19822 X

20.0 AN960C716L WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M102029 X

M104093 Y

21.0 MS210434 Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M100651

✓ 120X M102959

7/4/09 S9

Date: Friday, 06/04/2007 3:05:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 31709

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

22.0 NAS1515H4L Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description
32 NAS1515H4L Washer

Batch

M101428 ✓ ✓

23.0 NAS1515H6L Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description
8 NAS1515H6L Washer

Batch

M18115 ✓

24.0 NAS1515H7L Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description
16 NAS1515H7L Washer

Batch

M100727 ✓

25.0 D3407041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description
1 D3407-041 TOW RING

Batch

B30394 ✓

26.0 D34173 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D3417-3 WASHER

Batch

B32757 ✓

7/4/959

Date: Friday, 06/04/2007 3:05:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 31709

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

27.0 D34561 washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3456-1 WASHER

132757 1326946 ✓

28.0 AN4C7A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M101427 ✓

✓

7/4/989

29.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

20710502 ①
PC 7/5/2 ①

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location:

CHG003 PH 07.04.17

31.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207105114 ①

Job Completion



U 07-05-14

Date: Tuesday, 5/1/2007 8:36:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32123
 Estimate Number : 10756
 P.O. Number : N/A
 This Issue : 5/1/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 31710A

Drawing Name : FLOAT SKID ASSEMBLY

REFERENCE ONLY

Part Number : D412742043
 Drawing Number : D3391 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : UR F 07.05.01
 Material : N/A
 Due Date : 5/8/2007 Qty: 1 Um: Each

Written By : 07.05.01
 Checked & Approved By : 07.05.01
 Comment : Est Rev A 05.10.13 New Issue KJ/JLM
 Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 GH0001 CHG003

2.0 D25775 Wearplate, Centre



07.05.01

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D25775 Wearplate
 D3564-5

B32054 *

D3566-5 Gasket

B31421

3.0 D3391023 Mid Tube Assembly



①

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly

B31848

m-h 07/05/01

4.0 D3391025 Aft Tube Assembly



①

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-025 Aft Tube Assembly

B31440
 B30925

m-h 07/05/01

N

D3391-021

B30925

m-h 07/05/02

①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 32123

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34601

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
pick:

Qty Part Number Description Batch
1 ~~D3460-4~~ Wearplate B331417
D3564-1

D3566-1 Gasket B331418 ^{mt} 07-05-01

6.0

D34603

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
pick: D3564-3

Qty Part Number Description Batch
1 ~~D3460-3~~ Wearplate B31419

D3566-1 Gasket B31418

7.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)
pick:

Qty Part Number Description Batch
24 AN3C4A Bolt M103691

8.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)
pick:

Qty Part Number Description Batch
12 AN3C6A Bolt M103693

9.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
pick:

Qty Part Number Description Batch
8 AN3C7A Bolt M19522

10.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)
pick:

Qty Part Number Description Batch
44 AN960C10L Washer M104215

m-l 07/06/01

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 32123

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

NAS1515H3L

WASHER



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

pick:

Qty Part Number Description

Batch

44 NAS1515H3L Washer

PH

07-05-01

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3

M104161

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291

M103561

Expiry date:

07-10

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon

M117168

A/R Sikaflex-241/-291

M103561

Expiry date:

07-10

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP

B 3 363

Ce 7/8/11 SQ

Date: Monday, 1/22/2007 7:55:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30363
 Estimate Number : 10366
 P.O. Number : *NIA*
 This Issue : 1/22/2007 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : LANDING GEAR
 Previous Run : 30362

Drawing Name : FLOAT SKIDTUBE

Part Number : D412742013
 Drawing Number : UNDER REVIEW
 Project Number : N/A
 Drawing Revision : N/A
 Material : *NIA*
 Due Date : 2/15/2007

REFERENCE ONLY

Qty: 1 Um: Each

Written By : *JA 07.01.22*
 Checked & Approved By : *JA 07.01.22*
 Comment : Est Rev: A 05.10.13 New Issue KJ/JLM
 Est Rev: B 06-06-08 As per DSI9336 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07.0419

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 & DSI 9330 & DSI 9336 CHG004 + *DSI 9336 07.01.22*

2.0 30363A FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B *B30363A B 32123*

3.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside

B30094 ✓

4.0 D2572 Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside

B30593 ✓

5.0 D2573 Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

CP 07/04/09

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Number: 30363

Part Number: D412742013

Number:



Seq. #:

Machine Or Operation:

Description:

1 D2573

Saddle Aft Outside

B 30214

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2574

Saddle Aft Outside

~~B 30595~~ ✓ B 30595

7.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2747

Bolt

B31300 ✓ ✓

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2876

Saddle Spacer

B28016 ✓ ✓

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2877

Saddle Spacer

B28481 ✓ ✓

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D3403-1

Bushing

B30921 (15) ✓ B



B31712 ✓

11.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3403-3

Bushing

B30989 6X

B30393 2X

C/Box/04/09

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Number: 30363

Part Number: D412742013

Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

626514 ✓

13.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

B26515 ✓

14.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

M102039 ✓

15.0

AN4C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C6A

Bolt

M19529 ✓

16.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

M100340 ✓

17.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

M101467 ✓

CP 107/109/090

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Number: 30363

Part Number: D412742013

Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 AN960C416L

Washer

M100651 ✓ ✓

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C616L

Washer

M18822 ✓ ✓

20.0

AN960C716L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M102029 ✓ ✓

21.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M102959 ✓ ✓

22.0

NAS1515H4L

Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 NAS1515H4L

Washer

M102959 (15) M101428 (15) 10/10/09

Process Sheet

er: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Number: 30363

Part Number: D412742013

umber:



Seq. #: Machine Or Operation: Description :

23.0 NAS1515H6L Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	NAS1515H6L	Washer	M18918 ✓ ✓

24.0 NAS1515H7L Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	NAS1515H7L	Washer	M100727 ✓ ✓

25.0 D3407041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-041	TOW RING	B30394 ✓ ✓

26.0 D34173 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3417-3	WASHER	B27571 ✓ ✓

27.0 D34561 washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3456-1	WASHER	B26946 ✓ ✓

Boat/p4/p90

Process Sheet

ier: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Number: 30363

Part Number: D412742013

umber:



Seq. #:

Machine Or Operation:

Description :

28.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 1101427 - V

Boat 1/4/09 ①

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207104123 ①

27/4/23 ①

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013 + ~~07-01-03~~

Location: Reus

CHG003

07-01-03

07-04-07

59

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07105114 ①

Job Completion



U 07-05-14

Date: Friday, 2/23/2007 1:47:37 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD TUBE ASSEMBLY	REFERENCE ONLY PH 07.02.26
Job Number : 30925	Part Number : D3391021	
Estimate Number : 10467	Drawing Number : D3391 UNDER REVIEW	
P.O. Number : N/A	Project Number : N/A	
This Issue : 2/23/2007 S.O. No. : N/A	Drawing Revision : EF	
Prsht Rev. : NC	Material : N/A	
First Issue : N/A	Due Date : 3/21/2007	Qty: 1 Um: Each
Previous Run : 30924		
Written By : <u> </u>		
Checked & Approved By : <u> </u>		
Comment : Est. A 05.09.13 New issue KJ/JLM		
Est. B 06.02.10 Dwg rev.D ecn 773 EC		
Est. C 06.05.02 Added inspections EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D6013047	SKIDTUBE MAT'L
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	B 26547

JD 7-3-22

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
 Cut extrusion to 46.52 +0.010 -0.020

JD 7-3-8

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: No bender
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-3-28

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-3-29

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. E
 Identify as D3391-1

2-Deburr

BG 01.04.02 (1)

Friday, 2/23/2007 1:47:37 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 30925

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Feb

07/04/27 ①

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

m-103278

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

Feb

07/04/27 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-01 ①

17.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

B31346

18.0

AN3C4A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

M103691

*TURNU
OVER*

19.0

NAS1515H3L

WASHER



①

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

m-1 07/05/03



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Friday, May 2

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EXPEDITED QUOTE

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QUOTE IN U.S. DOLLARS

Quote ID (if calling Customer Service Center) **39319894**
 Exact Express Ground **\$1,191.78**
 Canadian Dollars **\$1,241.24**

Use this Exact Express Ground quote to easily

CREATE BILL OF LADING / PICKUP

I want to create a pickup only.

SERVICE

Service Days

3

Guaranteed Delivery Date (ship by 05/02/2008)

05/06/2008

Your shipment must be ready for pickup by 5 p.m. to qualify for the service days indicated.

Quote Other Yellow Services

Standard Ground

Truckload

CHARGE DETAIL

Base Charge \$793.20
 100% Satisfaction Guarantee Included
 Proactive Notification Included
 Value-Added Services \$140.00
 BORDER CHARGE US-CAN GROUND \$0.00
 OVER DIMS TIER 1 GROUND \$140.00
 FUEL SURCHARGE-EE INNET \$258.58

Pricing Days 3
 Trade Show No
 Price / GLB 0.6000
 Portfolio ID YELL32005
 Table of Rates 320050
 GLB 1322

*Exact Express Ground quotes expire at 5 p.m. on the pickup day. To finalize, click Schedule Pickup Now or call our Customer Service Center at 1-800-610-6500, option 4.

COPY QUOTE**NEW QUOTE**

IMPORTANT: When using Exact Express service, please write "Exact Express" on the Bill of Lading.

Quote generated through the Internet on
 05/02/2008

QUOTE REQUEST DETAILS

Origin K6A1K7
 (Served by OTTAWA, ON, CN - Direct)
 Destination 70518
 (Served by LAFAYETTE, LA - Direct)

Requested Pickup Date 05/02/2008

Requested Delivery Date 05/06/2008 By 5PM

Miles 1738

PIECES	WEIGHT	CLASS	LENGTH	WIDTH	HEIGHT	UN	NA
1	38	-	97	34	7	-	-
7	420	-	113	34	7	-	-
4	58	-	120	7	7	-	-
2	200	-	150	12	6	-	-

Total: 716 lb

Requestor BRIGITTE GOLDEN

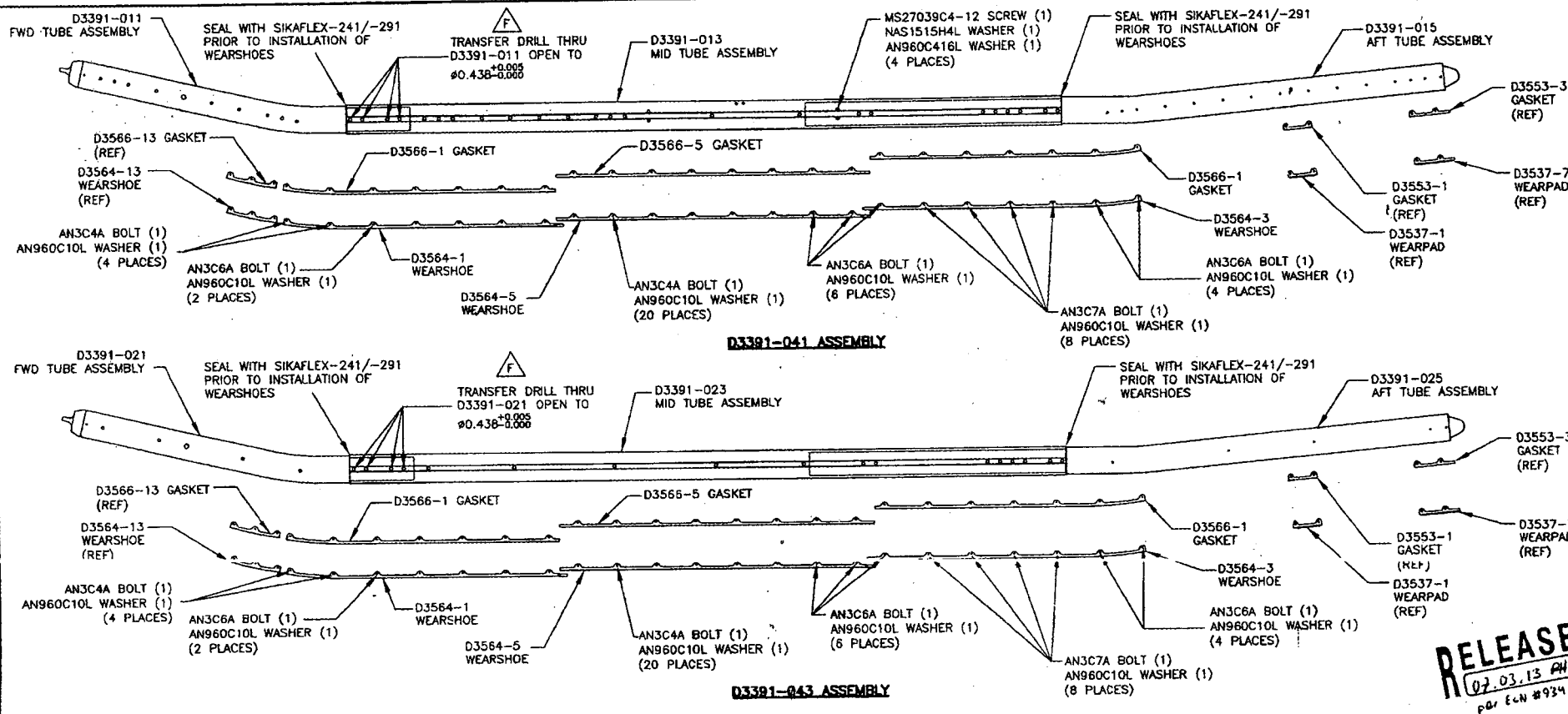
Please note: Yellow provides quote information for your convenience. The quotes below contain information valid at the time of the quote and, as such, may not reflect current service, availability or pricing. If you have questions, please call the Yellow Customer Service Center at 1-800-610-6500.

If a shipment is not identified as a full "Pup" or "Set" at booking but occupies the "full visible capacity" of either a Pup or Set as identified by Yellow Transportation, the shipment will be rated as either a full Pup or full Set plus any overflow. Full visible capacity occurs when one more of the largest pieces in the shipment will not fit on the trailer. Standard, undiscounted Exact Express Pup and Set rates in effect at the time of the shipment will prevail in the case that no customer-specific pricing program is applicable.

The Exact Express rates quoted here do not apply to shipments to or from trade shows. Please call the Yellow Customer Service Center at 1-800-610-6500, option 4, for Exact Express rates involving trade shows.

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RELEASED
07.03.13 RH
PDR ECH #934

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
5	5	AN3C7A	BOLT
4	4	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C/SINK Ø0.391/Ø0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE
		REV. F
		SHEET 1 OF 5
		SCALE
		NTS

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 30925

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

4

NAS1515H3L

Washer

M103641

20.0

AN960C10L

washer



10 PH 07.05.02

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
washer

M104215

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Install tow Cap as per Dwg D3391
Identify as D3391-021

M.A. 07/05/03

22.0

QC5

INSPECT WORK TO CURRENT STEP



J 070511

Comment: INSPECT WORK TO CURRENT STEP
Inspect thread of each insert using DT8821

23.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

PRP B 30363

P 1/5/11 59

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P 070511

Job Completion



U 07-05-11